

Work Order ID 84534

84534

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May-15-12 12:42:28 PM

Item ID: D3067-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: End Plate
 Start Date: 15/05/2012 Start Qty: 60.00 ***60*** Cust Item ID:
 Required Date: 24/05/2012 Req'd Qty: 60.00 ***60*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3067	Rev A

100 FLOW WATER JET 0.00

100 Waterjet Memo 0.00 B12-5-16

FLOW CNC Waterjet
 1-Cut as per Dwg D3067
 Dwg Rev: A
 Prog Rev: A
 2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110 QC Memo 0.00 B12-5-16

Quality Control

120 QC8- Inspect parts - second check 0.00

120 QC Memo 0.00 8/7/05/16 counting 075

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3067-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: End Plate

Start Date: 15/05/2012 Start Qty: 60.00

60

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

NC BRAKE

Memo

0.00

0.00

Brake NC

Bend as per Dwg D3067

75

12/05/22

140

140

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Quality Control

8-2/05/22

175

150

150

Packaging

Identify as per dwg & Stock Location: *WHA*

Memo

0.00

0.00

Packaging

*** STOCK IN STEP CELL***

15

12.05.24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D3067-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: End Plate

Stop ***NS2***

Start Date: 15/05/2012 Start Qty: 60.00

60

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/5/2948
MCS 12/05/20

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 84534

84534

Parent Item: D3067-1

D3067-1

Parent Item Name: End Plate

Start Date: 15/05/2012

Required Date: 24/05/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: 03.01.21 Remove step 6 (Deburr) KJ
IPP Rev:B Now on Water jet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased		No		100	sf	61.8526	0.0625	3.947368	S,		

M5052H32S 063

5052-H32 .063 Sheet

**

B12-5-16

Location

MAT022

114322

120603

Loc Qty

61.852632

12.852632

49

Loc Code

120603

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Dart Aerospace Ltd

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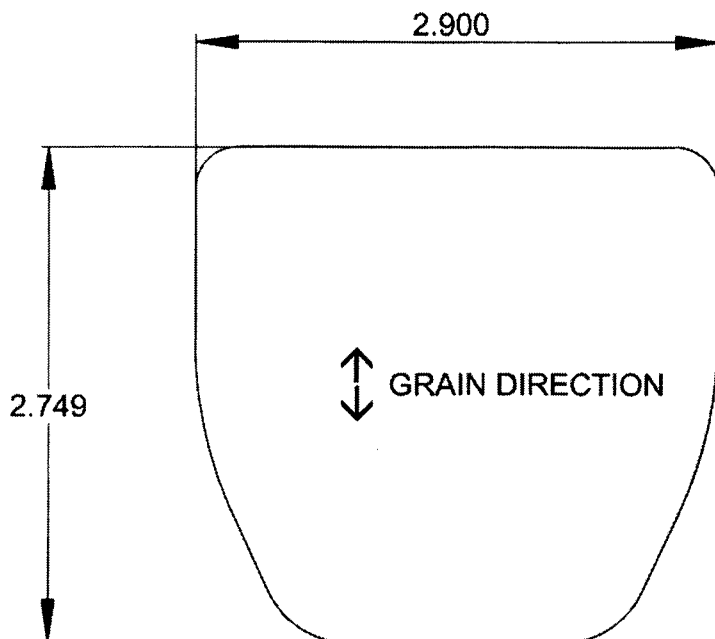
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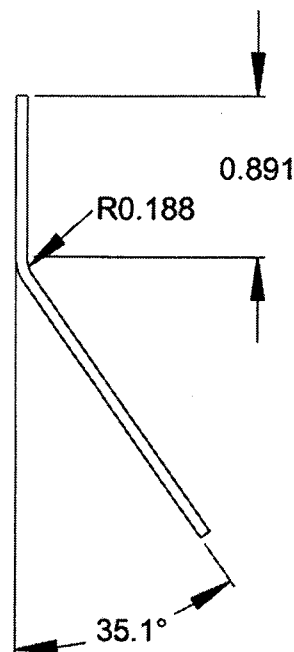


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84534 M65
12/05/11

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRPT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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